Thursday, 08/03/2007 1:16:38 PM

User:

Linda Lacelle

**Process Sheet** 

Customer : CU-DAR001 Dart Helicopters Services

**Job Number** : 31031A **Estimate Number** : 10839

P.O. Number This Issue

: 11A : 08/03/2007 S.O. No. : NA

Prsht Rev. : 07/03/2007 First Issue

: NIA **Previous Run** 

Written By Checked & Approved By

Comment

: Est: D 05.02.04 Added Step 9 KJ/RF

: SMALL /MED FAB

**Drawing Name** 

: LUG

Part Number : D22491 **Drawing Number** : D2249 REV. E

: N/A **Project Number Drawing Revision** 

: NA Material : 10/04/2007 **Due Date** 

10 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M304S16GA

304/316 .063 Sheet



Comment: Qty.:

0.0903 sf(s)/Unit Total: 0.9030 sf(s)

304/316 .063 Sheet Batch: M101463

MA 01 03 14 FLOW WATER JET

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: \_ & Prog Rev:

2-Deburr if necessary

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

Comment: SECOND CHECK

SECOND CHECK



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_/

22

Date:

,Thursday, 08/03/2007 1:16:38 PM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LUG** 

Job Number: 31031A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(10)

Job Completion



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Wednesday, 3/7/2007 8:38:06 AM

User: Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31031A

**Estimate Number** 

: 10839

P.O. Number

: 3/7/2007 This Issue

: NC Prsht Rev.

First Issue : 11

Previous Run

Written By

Comment

Checked & Approved By

: Est:

Type

S.O. No. :

: SMALL /MED FAB

Added Step 9

KJ/RF

Drawing Number

Project Number **Drawing Revision** 

**Drawing Name** 

Material

Part Number

**Due Date** 

: D22491

: LUG

D2249 REV. E

: N/A

; E

: 4/10/2007

Qty:

10 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description: PAURCHASING

1.0



Comment: PURCHASING

Issue P/O:

Email or ship DXF file to vendor Laser Cut D2249-1 as per Dwg D2249

Material release note required

D22491F

2.0

3.0

Lug



Comment: Qty.:

1.0000 Each(s)/Unit LUG

10.0000 Each(s)



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK

PACKAGING RESOURCE #1



Comment: DIMENSIONAL CHECK

Inspect dimensions as per template D2249-1T1 & Dwg D2249

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr any rough edges

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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			,						
		•							
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:			

QA: N/C Closed: \_\_\_\_

Date: \_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Ammayal	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspecto		
211										
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NOTE: Date & initial all entries

Date:

Wednesday, 3/7/2007 8:38:06 AM

User: Kin

Kim Johnston

Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: LUG

Part Number: D22491

Job Number:

Job Number: 31031A

Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



NSPECT WORK TO CURRENT S

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_\_\_\_

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Job Completion



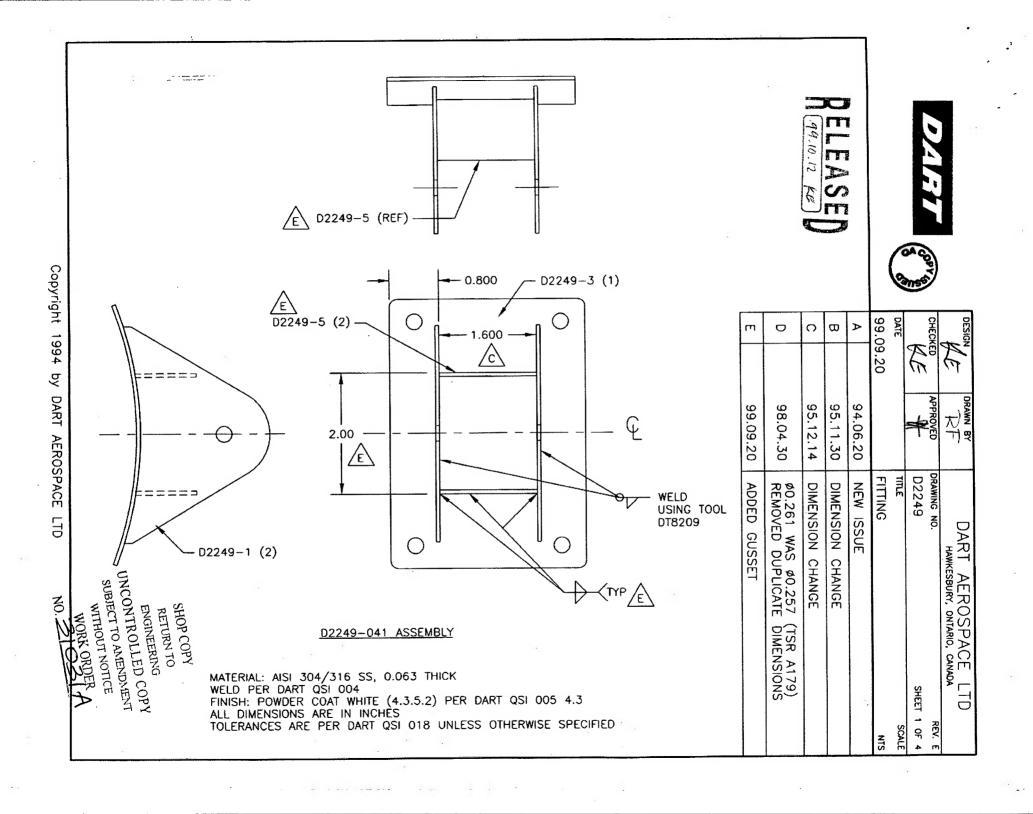
## **Dart Aerospace Ltd**

W/O:		Status Asper	WORK ORDER O	HANGES	NGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1.									
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	L	

QA: N/C Closed: \_\_\_\_ Date: \_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto		
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NOTE: Date & initial all entries

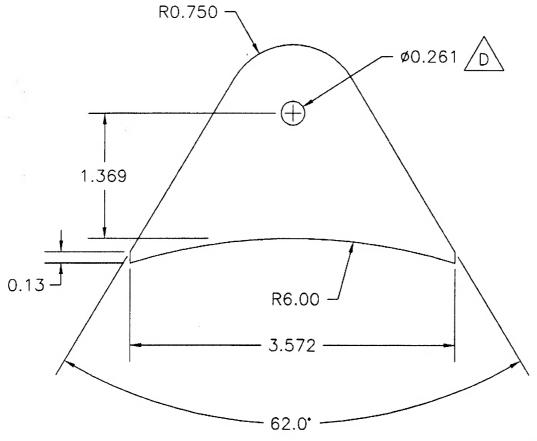






DESIGN KE	PF	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROYED	DRAWING NO.	REV. E
#E	<del>       </del>	D2249	SHEET 2 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1





D2249-1 LUG

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

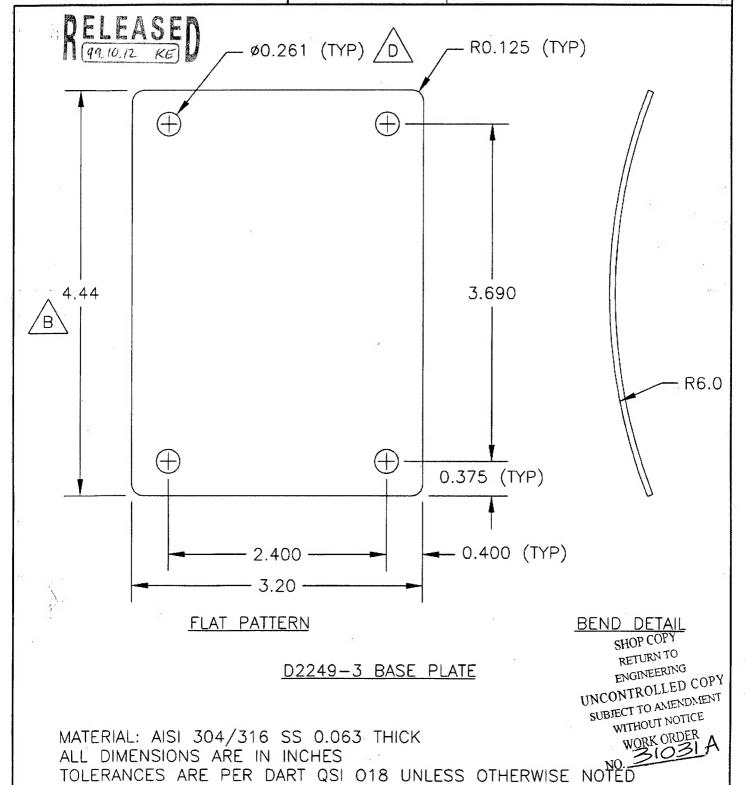
WITHOUT NOTICE

WORK ORDER, A

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
 CHECKED HE	APPROYED	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE	•	TITLE	SCALE
99.09.20		FITTING	1:1

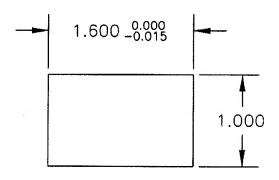






DESIGN	DRAWN BY		AEROSPACE LTD BURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2249	SHEET 4	REV. E OF 4
DATE		TITLE		SCALE
99.09.20		FITTING		1:1





D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED TO AMENDMENT

SHOP COPY RETURN TO ENGINEERING

DART AEROSPACE LTD	Work Order: 31031A
Description: Lug	Part Number: D2049-1
Inspection Dwg: 73249 Rev: E	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$0.261	10.00L - 0.001	0.261	<b>V</b>		vern	
1.369	H-0.010	1.310	1		VEIN	
3.572	+1-0.010	3.512	1		vern	
0.13	H-0.030	0.13	1		VerN	
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Measu	ıred by:	ml.ml	Audited by:	Prototype Approval:	MM
	Date:	07 03 14	Date: 0.03.14	Date:	10/17/
Rev	Date	Change		Revised b	y Approved
l		Now Issue		K I/.II M	

